

METHOD AND DEVICE FOR TRANSFERRING ARTICLES

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INVENTOR(S)- GRETENER, Urs Treppenweg 18, CH-5300 Ennetburgi
Switzerland

INVENTOR(S)- HEINZ, Beat Compardans, CH-7411 Sils im Domleschg
Switzerland

INVENTOR(S)- RYKART, Ruedi Waltersholz 49, CH-5046 Schmidrued
Switzerland

APPLICANT(S)- SIEMENS SCHWEIZ AG EP/Patente, Postfach, Albisriederstrasse
245, CH-8047 Zurich Switzerland

APPLICANT(S)- GRAPHA-HOLDING AG Seestrasse 41, Postfach 170, CH-6052
Hergiswil Switzerland

APPLICANT(S)- GRETENER, Urs Treppenweg 18, CH-5300 Ennetburgi
Switzerland

APPLICANT(S)- HEINZ, Beat Compardans, CH-7411 Sils im Domleschg
Switzerland

APPLICANT(S)- RYKART, Ruedi Waltersholz 49, CH-5046 Schmidrued
Switzerland

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ATTORNEY, AGENT, OR FIRM- SIEMENS SCHWEIZ AG, EP/Patente, Postfach,
Albisriederstrasse 245, CH-8047 Zurich, Switzerland

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The method described controls the transfer of articles (FS) which are to be delivered within the shortest possible time by a delivery conveyor (AGF) to unoccupied places on a receiver conveyor (ANF). The receiver conveyor (ANF) moves at constant speed V_{sub} ANF (end sub) and makes an angle (small alpha, Greek) with the delivery conveyor (AGF) which is divided into at least a buffer belt (PB), an acceleration belt (AB; AB1, AB2) and a transfer belt (EB). The following parameters: the instantaneous speed v_{sub} UE (end sub) of an article at time t_2 , the speed v_{sub} ES (end sub) at which the article has to be delivered, following acceleration, onto the transfer belt (EB), the measured length of the article I_{sub} FS (end sub), the length I_{sub} AB (end sub) of the acceleration belt (AB; AB1, AB2), at least approximately the length of the path (b_{sub}) AB (end sub) * $\tan(\text{small alpha, Greek})$ which the article (FS) has already covered, following the length measurement at time t_2 , on the acceleration belt (AB; AB1, AB2)

and the position of the next unoccupied place on the receiver belt (ANF) parameters which can be measured and/or adjusted by a control unit (ST1, ST2), are used to determine the length of time $t'_{\text{sub SYN}}$ during which the article (FS) with an acceleration a will have to be accelerated and decelerated, or decelerated and accelerated, in order that, when the article is delivered onto the transfer belt (EB), it is synchronized with the next unoccupied place on the receiving conveyor (ANF). The method and device proposed make it possible to reduce disruptive dead time in the transfer of articles of the same or different sizes. In addition, the method proposed brings about an acceleration of the transfer operation, calculated as a function of the position of the container into which an article is to be transferred and the size of the article, and makes it possible to synchronize the time of arrival of articles with that of unoccupied containers which, in prior art methods, would arrive too early and would travel past, unused, on the receiver conveyor.